

Date: Wednesday, 24/09/2008 12:47:51 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HYDRAULIC CYLINDER				
Job Number	: 42266		Part Number	: 41232 200 007 001				
Estimate Number	: 12750		Drawing Number	: 41232-200-007 REV IR				
P.O. Number	:		Project Number	: N/A				
This Issue	: 24/09/2008	S.O. No. :	Drawing Revision	: IR				
Prsht Rev.	: NC		Material	:				
First Issue	: / /	Type	: PURCHASED PARTS		Due Date	: 20/10/2008	Qty:	19
Previous Run	: 39219		Um:	Each				
Written By	:							
Checked & Approved By	: JUD 08.9.24							
Comment	: Est Rev:A New Issue 07-02-23 JLM							

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	7D 1 H	Clippard Brass Cylinder 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Spring (Step Actuator)		
2.0	PG	PURCHASING 
Comment: PURCHASING Issue P/O: <u>7244</u> <span style="margin-left: 100px;">C 208/09/25</span> Possible Supplier: Wainbee Material release note is required		
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached		
4.0	QC5	INSPECT WORK TO CURRENT STEP  <span style="font-size: 2em; margin-left: 100px;"><u>L. Stoltz (10)</u></span>
Comment: INSPECT WORK TO CURRENT STEP <span style="font-size: 2em; margin-left: 100px;"><u>8.08/10/17 (10)</u></span>		
5.0	SPRAY PAINTING	SPRAY PAINTING  <span style="font-size: 2em; margin-left: 100px;"><u>7-10-24</u></span>
Comment: SPRAY PAINTING Mask threaded ends and threaded holes. 1-Apply polymide primer Batch: <u>109 278</u> 2-Apply polyurthane coating gloss black Batch: <u>109 278</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 24/09/2008 12:47:51 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HYDRAULIC CYLINDER

Job Number: 42266

Part Number: 41232 200 007 001

Job Number:



Seq. #: Machine Or Operation:

Description :

Note: Paint Nut on threaded end and leave attached to assembly

08-10-29 (10)

6.0 QC14 INSPECT SPRAY PAINT



m 08 10 29



Comment: Inspect Spray Paint

7.0 PACKAGING 1 PACKAGING RESOURCE #1



(10x)

Comment: PACKAGING RESOURCE #1

Install Decal then

Identify and Stock

Location: 262

8/10/29

SD

8.0 QC21 FINAL INSPECTION/W/O RELEASE



08/10/31 (10)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



WF 08-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DATE 2/26/04	ENGINEERING ORDER		E.O. No. B-1	SHT. <u>1</u> OF <u>1</u>
BY D. NELSON	TITLE STEP ACTUATOR COMPONENTS		DWG. AFFECTED 41232-200-002	
APPROVED BY			SHEET AFFECTED SHT 1 & 3	
REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.				
MINOR CHANGE - FAR 21.95				

*Perf*  
NO  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

IS

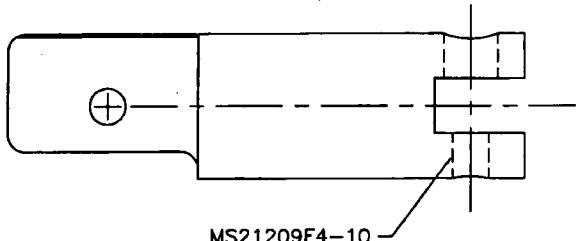
1	MS21209F4-10	INSERT
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WAS

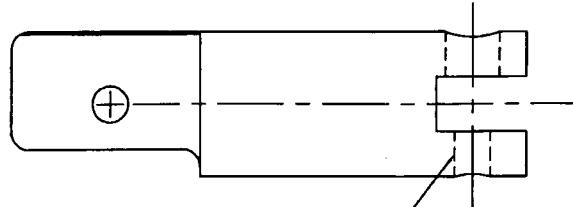
1	MS21209F4-15	INSERT
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IS

WAS

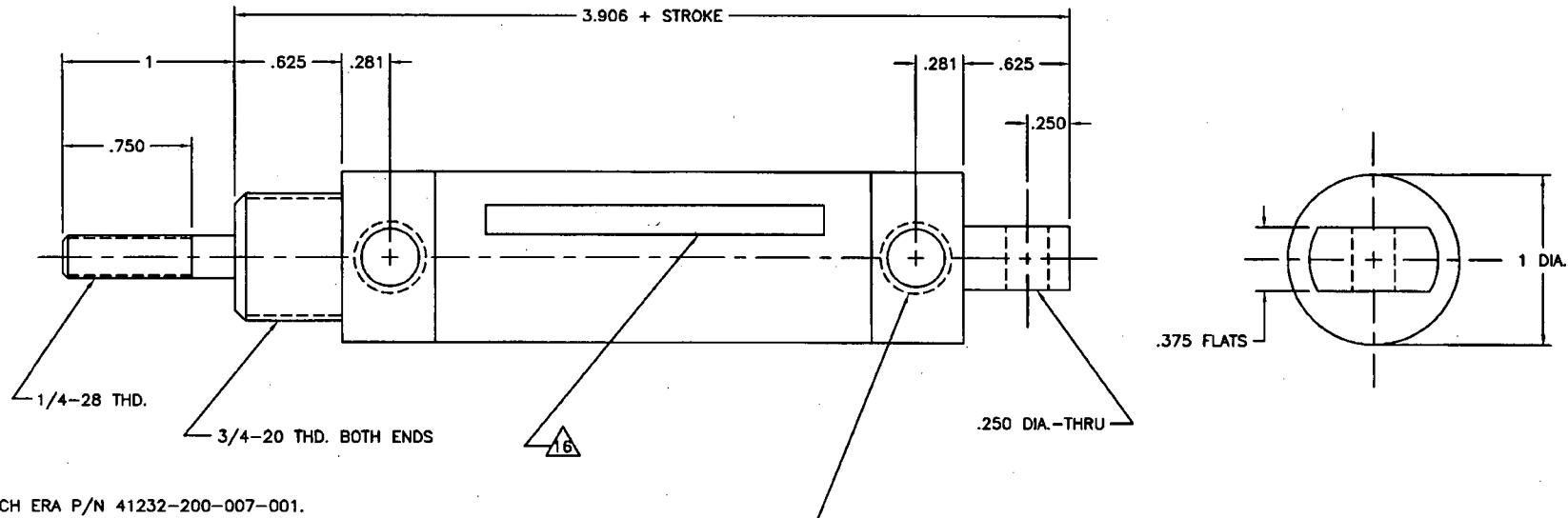


-005 PIVOT ARM



-005 PIVOT ARM

CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				



**16** VIBRO ETCH ERA P/N 41232-200-007-001.

15. APPLY POLYURETHANE COATING, GLOSS BLACK (535U)  
IN ACCORDANCE WITH ERA PROCESS SPECIFICATION 4009

14. APPLY POLYMIDE PRIMER IN ACCORDANCE WITH  
ERA PROCESS SPECIFICATION 4004.

13. PRESSURE TEST: 2660 PSI (USE 5606 FLUID).

NOTE - ALTER 7D1H ASSY IN ACCORDANCE WITH  
INSTRUCTIONS LISTED ABOVE.

12. SINTERED BRONZE ROD BUSHING.
11. ROD DIAMETER: 0.25 INCHES.
10. PORTS: 1/8 NPT.
9. POWER FACTOR: 0.6 SQ. IN.
8. STROKE: 1.000 INCH.
7. ACTION: DOUBLE ACTING.
6. MOUNT: UNIVERSAL MOUNT.
5. TEMPERATURE RANGE: 30° F TO 150° F.
4. 7D1H CONFIGURED WITH HYD. FLUID.
3. ROD: ROTATING.
2. BORE: 0.875 INCHES.
1. HEAVY DUTY BRASS CYLINDERS.

#### **NOTES:**

SHOT CO. 1  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4226(A)  
5-2

		-001	BRASS CYLINDER 7D1H	CLIPPARD INSTRUMENT LABORATORY, INC., CINCINNATI, OH.				
		PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC	ZONE	
NO. REQ'D PER ASSY		LIST OF MATERIAL						
PROPRIETARY RIGHTS NOTICE		<small>UNLESS OTHERWISE SPECIFIED X.±.1 XL.±.03 XXX.±.010 ANGLES ±1/2</small>	DRAFTSMAN CHECK STRESS PROJ. ENGR.	D. NELSON D. MURPHY	3/14/03 3/14/03	TITLE	HYDRAULIC CYLINDER (ALTERED ITEM DRAWING)	
THESE DATA ARE PROPRIETARY TO CLIPPARD INSTRUMENT LABORATORY, INC. AND ARE FOR INTERNAL USE ONLY. THEY ARE NOT TO BE DISCLOSED, REPRODUCED, OR USED FOR ANY PURPOSE EXCEPT FOR WHICH THEY WERE FURNISHED. CLIPPARD INSTRUMENT LABORATORY, INC. IS AN AFFILIATE OF ERA AVIONICS, INC. THESE DATA ARE NOT TO BE USED FOR ANY OTHER PURPOSE. THESE DATA DO NOT APPLY TO OTHER PARTS.			HEAT TREAT	FINISH	DWG. SIZE C	SCALE NONE	DWG. NO. 41232-200-007	REV. IR
-001 2 41232-000-001			REVIS. DATE DWG. NO.	<i>Era Aviation, Inc.</i>				
NEXT ASSEMBLY			REV. NO.					



WAINBEE LIMITED  
215 BOUL BRUNSWICK  
POINTE CLAIRE, PQ H9R 4R7  
Phone: 514-697-8810 Fax: 514-697-3070

## Packing List

CUSTOMER P/O NUMBER
:PO00007244
RELEASE # 15017389-1
DATE 10/14/08 09:46:51

127404  
DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY, ON K6A 1K7  
613-632-3336

SHIP TO  
DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY, ON K6A 1K7

ORDER NUMBER 15017389	ORDER DATE 09/25/08	SHIP DATE 10/14/08	WRITTEN BY Hugues Roy	CONTACT CHANTAL LAVOIE(t)	
CUSTOMER P/O NUMBER :PO00007244					
JOB #					
RELEASE #					
PRODUCT / DESCRIPTION	QUANTITY OPEN	U/M	QUANTITY SHIPPED	QUANTITY BACKORDERED	PRICE / EXTENSION
7D-1-H	10	EA	10	0	80.440
CLIPPARD BRASS CYLINDER					804.40

S  
osdwl17

Wainbee's Standard Terms and Conditions Apply

Returned Goods Not Accepted Without Prior Authorization.

Claims For Shortages Or Losses Are Not Accepted 10 Days After Shipment.